

Work Order ID 65608

January 20, 2011 11:08:11 AM

Page 1

Item ID: D3908-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Lug Assembly, Aft

Start Date: 1/21/11 Start Qty: 6.00

Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: MF

Date: 11-01-20

Tooling:

Date:




QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3908	C								
100	Pick Kit	0.00							
									
Packaging	Memo	0.00							
Packaging									
110		0.00							
									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg TRIM RIVETS 1.185" LONG								
120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

ES 11/01/25 (6)

ES 11/01/25 (6)

(46)

8/16/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 20, 2011 11:08:07 AM

Page 1

Work Order ID: 65608

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft



Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
As per Rev B 10-04-06 VERIFIED BY:DD
10.05.27 DD verf:EC
10.05.28 DD verf:EC
IPP REV B:
IPP Rev:C as per PC1
IPP Rev:D per ECN10-581

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6 		Manufactured	No			100	Each	0.0000	1	6			
Lanyard Assembly								B65617 (6x)				1/21/11	
D3908-1 		Manufactured	No			100	Each	12.0000	2	12			
Lug Plate, Aft Crosstube												1/21/11	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST093				1					
				61829				1					
				ST094				6					
				60035				6					
				ST095				5					
				58344				5					
D3908-3 		Manufactured	No			100	Each	14.0000	1	6			
Stud Receiver, Lower												1/21/11	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST095				14					
				57816				2					
				58849				1					
				59453				1					
				60228				10					

B65624 (11x)

W/O:		WORK ORDER CHANGES					
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Picklist Print

January 20, 2011 11:08:08 AM

Work Order ID: 65608

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

D3908-5

 Eyebolt Stud

Manufactured No

100 Each

9.0000

1 6



Handwritten signature and date: 1/21/11

Location

Loc Qty

Loc Code

GA

1

57428

1


ST095

8

59670

8

6

D3910-1

 Crosstube Lug

Manufactured No

100 Each

20.0000

1 6



Handwritten signature and date: 1/21/11

Location

Loc Qty

Loc Code

st507

20


59708

1

64106

19

6

D4091-1

 Mounting Lug

Manufactured No

100 Each

14.0000

1 6



Handwritten signature and date: 1/21/11

Location

Loc Qty

Loc Code

ST460

14

61993

4

62392

10

4

2

W/O:		WORK ORDER CHANGES					
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Work Order ID: 65608



Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

AN3C12A Purchased No

100 Each

100.0000

2

12



Bolts

Location

Loc Qty

Loc Code

ST351

100

112314

8

114761

11

116022

2

116289

29

116428

50



EP 11/01/35

~~M116087~~

8912

AN4C13A Purchased No

100 Each

60.0000

1

6



BOLT

Location

Loc Qty

Loc Code

ST357

60

113359

3

114442

5

114615

2

116191

50



EP 11/01/20

6

MS17984-C413 Purchased No

100 Each

7.0000

1

6



PIN, QUICK RELEASE

Location

Loc Qty

Loc Code

ST315

7

116304

7

100

Each

174.0000

6

36



RIVET

Location

Loc Qty

Loc Code

ST323

174

114808

26

115054

148



EP 11/01/25

M115037 (36x)

January 20, 2011 11:08:08 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
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January 20, 2011 11:08:09 AM

Work Order ID: 65608

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

MS21043-3 Purchased No

100 Each

1,677.000

2

12



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1601

112314

1601

12

MS21043-4 Purchased No

100 Each

1,194.000

1

6



Nut

Location

Loc Qty

Loc Code

ST301

1194

114523

5

114784

2

115936

291

116188

596

116549

300

6

NAS1149C0332R Purchased No

100 Each

4,752.000

4

24



Washer

Location

Loc Qty

Loc Code

ST297

4752

115000

125

115698

35

116025

1592

116304

3000

24

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 1/21/11

Required Date: 2/04/11

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0432R

Purchased

No

100

Each

204.0000

2

12



Washer

Handwritten signature/initials

Location

Loc Qty

Loc Code

ST297

204

114292

50

114742

63

116304

91

Handwritten number 62

January 20, 2011 11:08:09 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

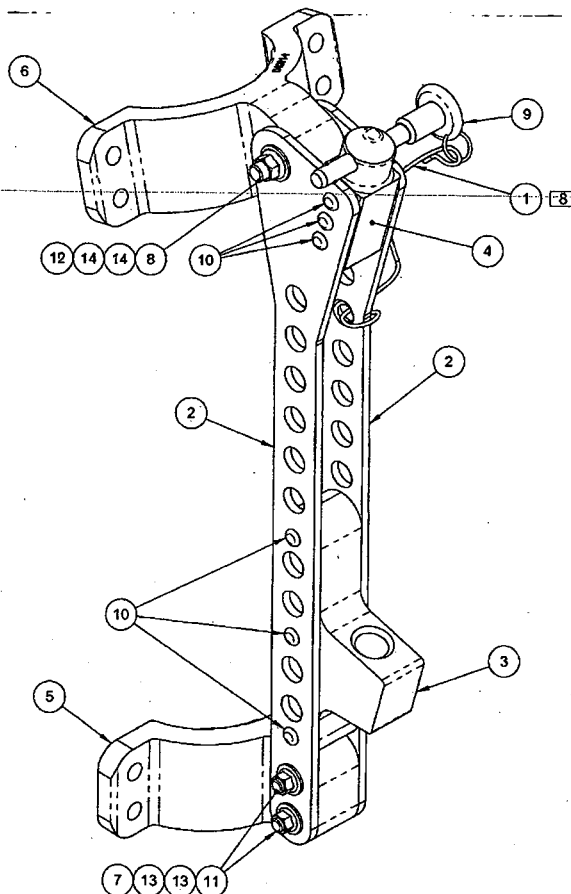
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ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



D3908-041 X-TUBE LUG ASSY (AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

RELEASED
2010-05-28
W

REV.	DESCRIPTION	BY	DATE
C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5, QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 6; ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3908 TITLE X-TUBE LUG ASSY (AFT) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. C SHEET 1 OF 5	
DATE	10.05.27		

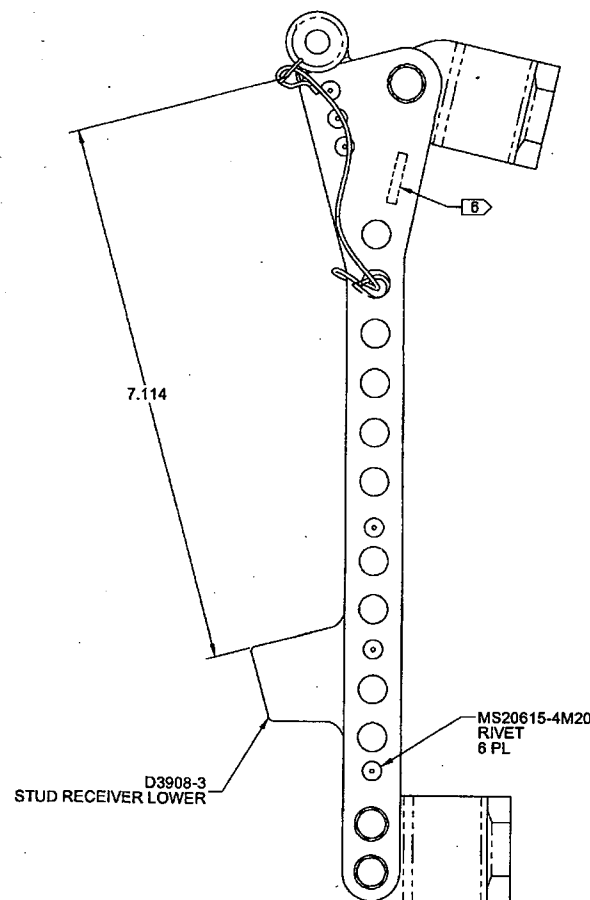
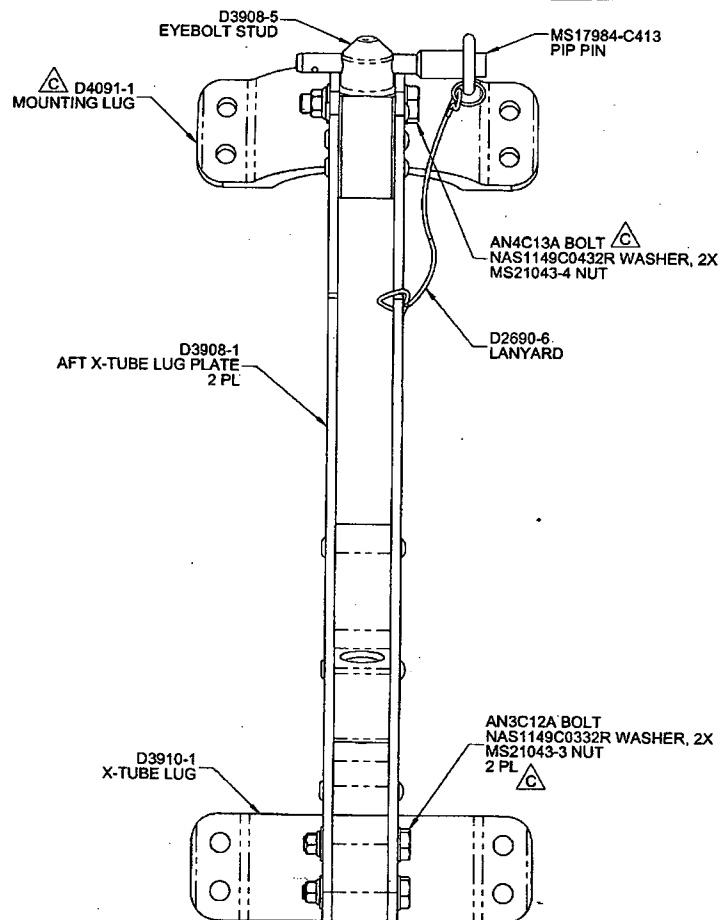
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NOTE: Date & initial all entries



#6508

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2010-05-28
JND

D3908-041 X-TUBE LUG ASSY (AFT)

DESIGN	JFH	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 2 OF 5
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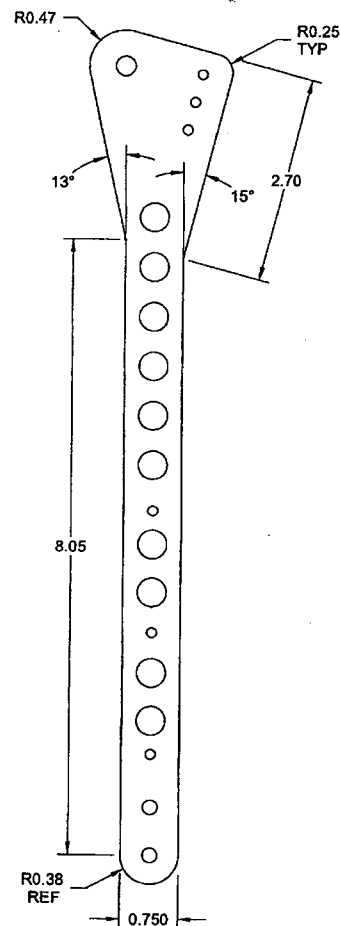
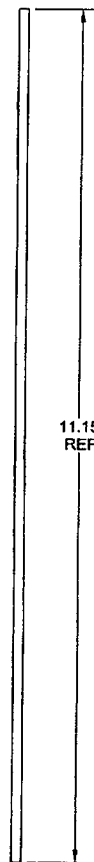
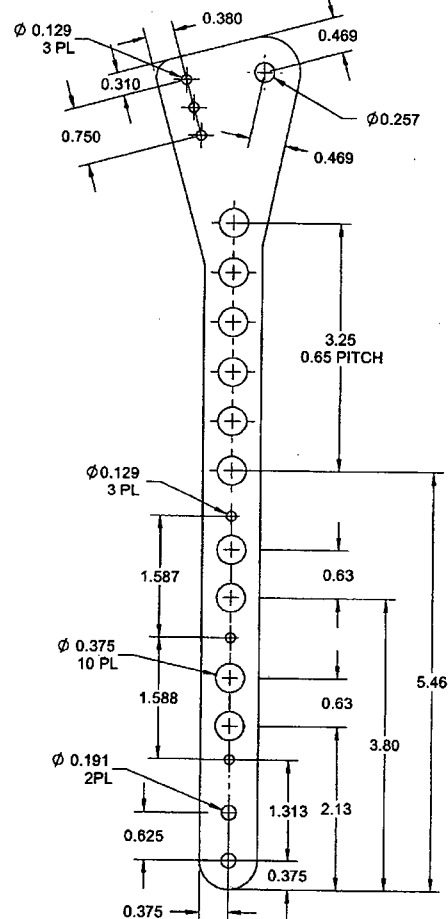
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NOTE: Date & initial all entries



#65008

RELEASED
2010-05-28
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

D3908-1 AFT X-TUBE LUG PLATE

DESIGN	JFH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
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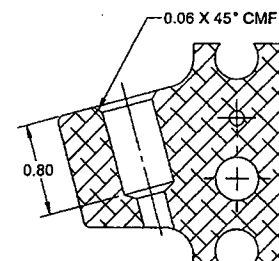
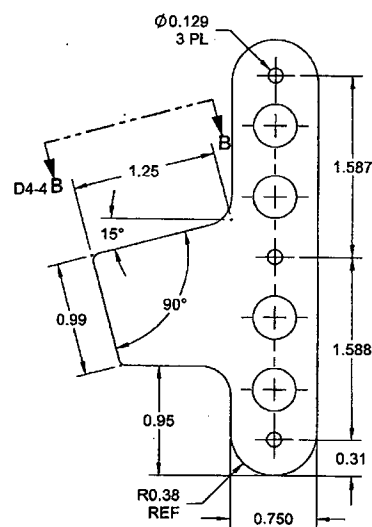
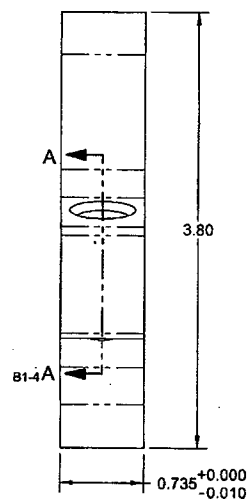
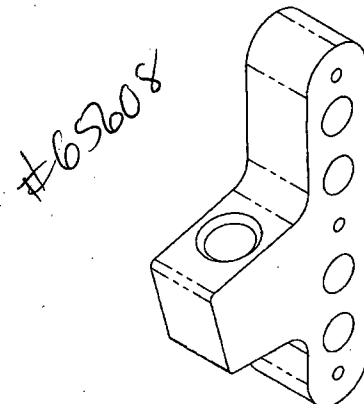
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NOTE: Date & initial all entries



RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
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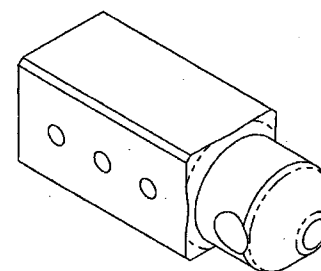
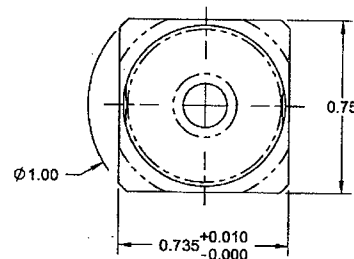
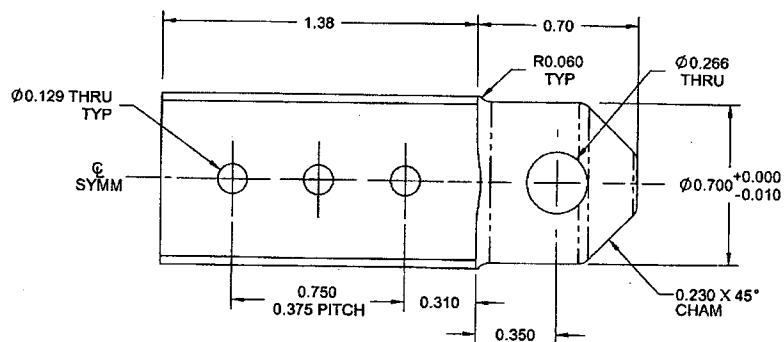
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NOTE: Date & initial all entries



#652008

D3908-5 EYEBOLT STUD

RELEASED
2010-05-28
MD

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
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